

# Work Order ID 112303

\*112303\*

Page 1

January-30-14 11:30:30 AM

Item ID: D3685-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bipod Mount Ass'Y  
 Start Date: 1/30/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 1/30/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: MCS Date: 14-01-31 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3685	F	

100 Pick Kit 0.00  
 \*100\*  
 Packaging Memo 0.00 2 FF 14-03-12  
 Packaging

110 Small Fab 0.00  
 \*110\*  
 Small Fab Memo 0.00 2 FF 14-03-12  
 Small Fab

1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly as per dwg. (SEE NOTE 8)

\*\*\*AFTER FINISH DRILLING AND REAMING PARTS MUST STAY TOGETHER. DO NOT MIXE THEM UP\*\*\*

2-Assemble D3684-049/-047 & D3687-3 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684

MAGNOBOND BATCH: 17125716

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 112303

January-30-14 11:30:30 AM

\*112303\*

Page 2

Item ID: D3685-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bipod Mount Ass'Y  
 Start Date: 1/30/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 1/30/14 Req'd Qty: 2.00 \*2\* Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
*120*		0.00				2			
QC	Memo								
Quality Control									

130	Identify as per dwg & Stock Location: _____	0.00							
*130*		0.00							
Packaging	Memo								
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
*140*		0.00							
QC	Memo								
Quality Control									

ML5 14-0312  
 MF  
 14-3-12

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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### FAULT CATEGORY

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# Picklist Print

January-30-14 11:30:29 AM

Page 1

Work Order ID: 112303  
Parent Item: D3685-041  
Parent Item Name: Bipod Mount Ass'Y

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL  
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
03-16 JLM VERIFIED BY:EC  
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD  
IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3684-047 Fwd Leg Ass'Y		Manufactured	No				Each	8.0000		2		FF 14-03-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st200		8							
				101593		1							
				102870		1							
				108000		2							
				109468		2							
				97521		2							
D3684-049 Aft Leg Ass'Y		Manufactured	No				Each	5.0000		2		FF 14-03-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st200		5							
				101594		2							
				102871		1							
				97108		1							
				97522		1							
D3687-3 Mount		Manufactured	No				Each	17.0000		2		FF 14-03-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		17							
				83611		4							
				93757		13							
HL32PB8-14 Pin		Purchased	No				Each	42.0000		8		FF 14-03-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		42							
				125436		42							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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Material									
Operator									
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Training									
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### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

January-30-14 11:30:30 AM

Page 2

Work Order ID: 112303

Parent Item: D3685-041

Start Date: 1/30/14

Required Date: 1/30/14

Parent Item Name: Bipod Mount Ass'Y

Start Qty: 2.00

Required Qty: 2.00

HL86-8

Purchased

No

Each

168.0000

8

Collar

FF 14-03-12

Location

Loc Qty

Loc Code

ST284

168

m126267

68

m127815

100

8

January-30-14 11:30:30 AM

Shop Packet Print

Page 2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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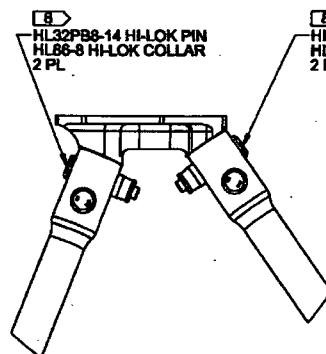
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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### FAULT CATEGORY

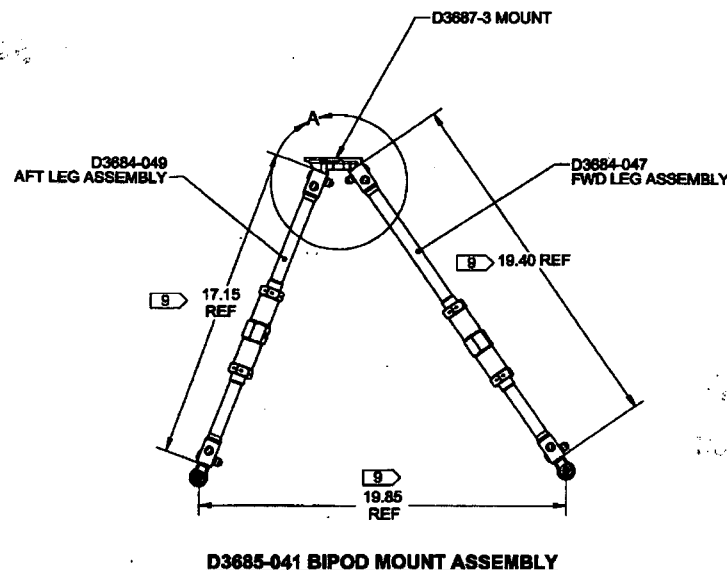
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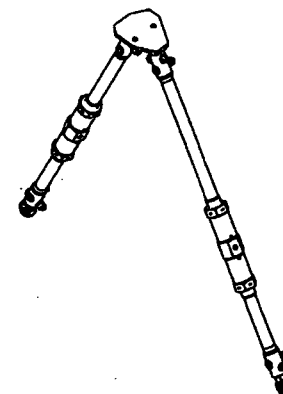
ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D3685-041	BIPOD MOUNT ASSEMBLY
1	1	D3687-3	MOUNT
2	1	D3684-047	FWD LEG ASSEMBLY
3	1	D3684-049	AFT LEG ASSEMBLY
4	4	HL32PB8-14	HI-LOK PIN
5	4	HL86-8	HI-LOK COLLAR



**DETAIL A**  
SCALE 3X



**D3685-041 BIPOD MOUNT ASSEMBLY**



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 PER DART QSI 044 6.1 ( FINE POINT PAINT MARKER )
- 7) WEIGHT: 8.68 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/-049 WITH D3687-3 USING HYSOL EA934NA OR MAGNOBOND 8398 ADHESIVE BETWEEN MATING SURFACES. HI-LOK PIN ORIENTATION AS PER DETAIL 'A'.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3689-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

F	ADD DETAIL A. REVERSE THE INSTALLATION ORIENTATION OF HI-LOK PINS TO FACILITATE ASSEMBLY PROCEDURE. CORRECT BOM TABLE.	DB	13.11.18
E	REMOVE ANSC-12A BOLT, D3687-1 SPACER AND N821043-3 NUT. REPLACE WITH HL32PB8-14 HI-LOK PIN. HL86-8 HI-LOK COLLAR. (ZN C3-1, ZN C5-1). RE-FORMAT NOTES SECTION AS PER QSI 043. CHANGE ASSEMBLY ADHESIVES. NOTES (ZN A2-1). CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE. (ZN D8-1) REF NCR 12-2974	DB	12.12.05
F	17.15 WAS 17.27 (ZN B5-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.85 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	06.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.V.	DRAWING NO.	REV. F
MFG. APPR.		D3685	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BIPOD MOUNT ASSEMBLY	NTS
DATE	13.11.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ALL RIGHTS ARE RESERVED BY THE COPYRIGHT HOLDER. NO PART IS TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	